

*Buted Reg. 4/01*  
**Work Order ID 55455**



Page 1

January 19, 2010 9:26:14 AM

Item ID: D3075-1

Accept



Setup Start



Revision ID:

Stop



Item Name: R44 Bearpaw

Start Date: 1/19/10 Start Qty: 8.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *RA*

Date: *10-1-19*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3075

Rev B

110

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D3075-1\_BLANK

*B 10-1-19*

*(12)*

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Note: (2) Bearpaw for (1) Kit 1-Inspect material for defects or damage prior to machining; 2-Machine as per Folio FA185 and Dwg D3076 Identify as D3075-1; 3-Deburr

*ML/ST 10/01/29*

*10 2*

*(PTO) →*

130

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*ST 10/01/29*

*10 2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3075-1 PAR #: \_\_\_\_\_ Fault Category: Machined Parts NCR: (Yes) No DQA: 2 Date: 10-02-17  
 Resolution: A & B Scrap Disposition: A & B Scrap QA: N/C Closed: 78 Date: 10/02/18

NCR: 55455		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/29	120	On Second Part when operator <del>change</del> <sup>changed</sup> program. The operator <del>change</del> <sup>changed</sup> the wrong Prog.	UP 10.02.01 per QS 042	- NO Replace. SCRAP	BF 10/01/29	S 10/02/01	UP 10.02.01 per QS 042	S 10/02/01
		R.C. operator error / Lack of attention						
10/01/31	120	1 part scrap .250" off on the Y axes. R.C. machine error	UP 10.02.01	no replace SCRAP	and 10/01/31	S 10/02/01	UP 10.02.01 per QS 042	S 10/02/01

NOTE: Date & initial all entries

# Work Order ID 55455

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Item ID: D3075-1

Accept

Setup Start

Revision ID:

Stop

Item Name: R44 Bearpaw

Start Date: 1/19/10 Start Qty: 8.00

Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 8.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

QC8- Inspect parts - second check

0.00

M.A 10/02/01

10 0

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

Packaging

Memo

PP55073

0.00

Packaging

10/02/12 10

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/12 10  
W10-12-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 19, 2010 9:26:19 AM

Page 1

Work Order ID: 55455



Parent Item: D3075-1



Parent Item Name: R44 Bearpaw

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM  
 IPP Rev:D Added C'Bores as per Rev B 07-03-28 JLM  
 IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC  
 IPP Rev:F 08-11-12 New Manufacturing Method JLM Verified By:EC

Start Qty: 8.00

Required Qty: 8.00

MUHMWB10 Purchased No 100 sf

431.9957 8.0000

10.



UHMW 1" Black

B 10-1-19

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	400.248	
112186	122.0164	
113166	76.1264	
113591	202.1052	
Main Warehouse		
ST	31.7477	
111354	31.7477	

113166

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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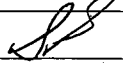
**NOTE:** Date & initial all entries


<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	55455
<b>Description:</b> R44 Bearpaw		<b>Part Number:</b>	D3075-1
<b>Inspection Dwg:</b> D3075 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                 
 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	.07	✓			
B	0.63	+/-0.030	.635	✓			
C	0.250	+/-0.010	.257	✓			
D	0.950	+0.030/-0.010	.858	✓			
E	5.50	+/-0.030	5.500	✓			
F	0.25 x 45°	+/-0.030	.240	✓			
G	0.900	+/-0.010	.900	✓			
H	0.375	+/-0.010	.384	✓			
I	1.30	+/-0.030	1.300	✓			
J	5.70	+/-0.030	5.70	✓			
K	0.37	+/-0.030	.379	✓			
L	3.600	+/-0.010	3.600	✓			
M	0.260	+0.005/-0.000	.260	✓			
N	0.93	+/-0.030	.928				
O	0.30	+0.030/-0.000	.306				
P	1.08	+/-0.030	1.08				
Q	5.870	+/-0.010	5.87				
R	10.14	+/-0.030	10.14				

<b>Measured by:</b>		<b>Audited by:</b>	B.A	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	6/2/25	<b>Date:</b>	10/02/01	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue      P/O D044-662-011	KJ/RF	
B	08.01.16	Dwg Rev updated	KJ/EC/DD	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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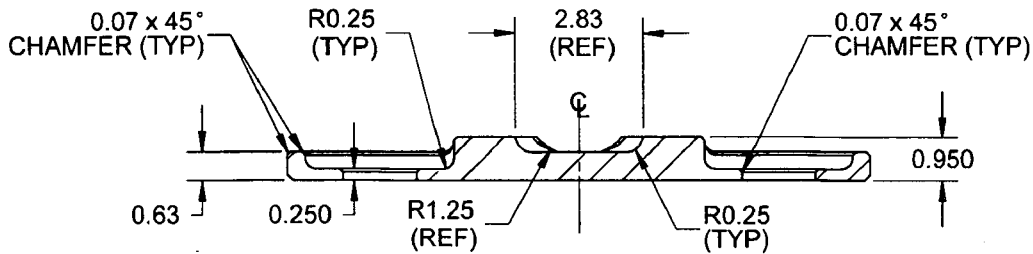
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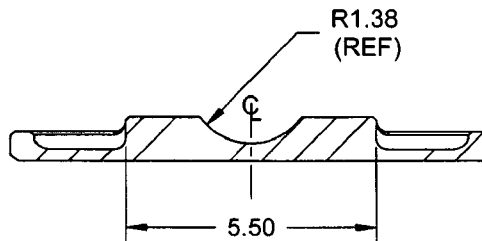


DESIGN #1	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3075	REV. B SHEET 2 OF 2
DATE 07.02.27		TITLE R44 BEARPAW	SCALE 1:4

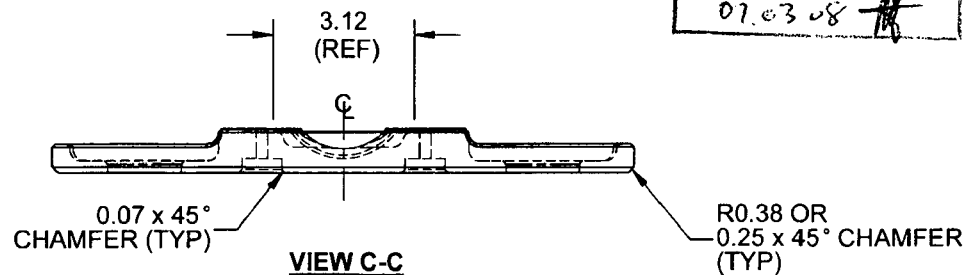
w/o 55455



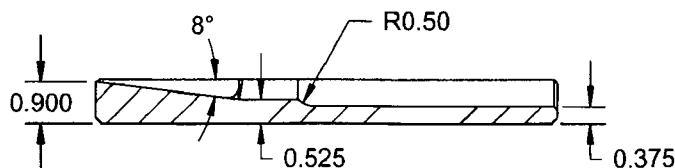
**SECTION A-A**



**SECTION B-B**



**VIEW C-C**



**SECTION D-D**

RELEASED

07.03.08

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